

What is claimed is:

1 1. A method of fabricating a trench device
2 structure with a single-side buried strap, comprising the
3 steps of:

4 providing a semiconductor substrate having a deep
5 trench therein;

6 forming a buried trench capacitor in a lower portion
7 of the deep trench;

8 forming a collar insulating layer lining an upper
9 portion of the deep trench

10 forming a first conductive layer overlying the
11 buried trench capacitor in the trench and
12 surrounded by and lower than the collar
13 insulating layer by a predetermined height;

14 removing a portion of the collar insulating layer
15 from the deep trench to expose a portion of the
16 semiconductor substrate;

17 forming a second conductive layer overlying the
18 first conductive layer in the deep trench,
19 wherein the second conductive layer is lower
20 than the surface of the semiconductor
21 substrate; and

22 forming the single-side buried strap region in the
23 semiconductor substrate directly contacting the
24 second conductive layer without isolation by
25 the collar insulating layer.

1 2. The method as claimed in claim 1, removal of
2 the portion of the collar insulating layer from the
3 sidewall of the deep trench further comprising:

4 sequentially forming a conformal lining layer and an
5 undoped polysilicon or amorphous silicon layer
6 on the surface of the semiconductor substrate
7 and inner surface of the deep trench above the
8 second conductive layer;

9 performing a tilt ion implantation on the undoped
10 polysilicon or amorphous silicon layer, wherein
11 a portion of the undoped polysilicon or
12 amorphous silicon layer in the deep trench is
13 not implanted;

14 selectively wet etching the undoped polysilicon or
15 amorphous silicon layer, thereby exposing the
16 underlying lining layer;

17 sequentially etching the exposed lining layer and
18 the contiguous collar insulating layer to
19 expose a portion of the semiconductor substrate
20 using the doped polysilicon or amorphous
21 silicon layer as a mask; and

22 removal of the remaining lining layer and the doped
23 polysilicon or amorphous silicon layer.

1 3. The method as claimed in claim 2, wherein the
2 lining layer is composed of silicon nitride.

1 4. The method as claimed in claim 3, wherein the
2 thickness of the silicon nitride is approximately 100Å.

1 5. The method as claimed in claim 3, wherein the
2 undoped polysilicon or amorphous silicon layer and the
3 silicon nitride lining layer are formed by low pressure
4 chemical vapor deposition (LPCVD).

1 6. The method as claimed in claim 2, wherein the
2 thickness of the undoped polysilicon or amorphous silicon
3 layer is between 50 and 100Å.

1 7. The method as claimed in claim 2, wherein the
2 dopant of the tilt ion implantation is BF₂ or B.

1 8. The method as claimed in claim 7, wherein the
2 tilt angle of the ion implantation is 7° to 15°.

1 9. The method as claimed in claim 7, wherein the
2 etching solution of the selectively wet etching is low
3 concentration ammonia solution.

1 10. The method as claimed in claim 2, removal of
2 the remaining lining layer and the doped polysilicon or
3 amorphous silicon layer further comprising:

4 oxidation of the remaining doped polysilicon or
5 amorphous silicon layer; and

6 sequential removal of the oxidized polysilicon or
7 amorphous silicon layer and the underlying
8 lining layer.

1 11. The method as claimed in claim 1, wherein the
2 collar insulating layer is composed of tetra ethyle ortho
3 silicate (TEOS) formed by chemical vapor deposition
4 (CVD).

1 12. The method as claimed in claim 11, wherein the
2 thickness of the collar insulating layer is from 200 to
3 300Å.

1 13. The method as claimed in claim 1, wherein the
2 first and second conductive layers are composed of doped
3 polysilicon.

1 14. The method as claimed in claim 13, wherein the
2 buried strap region in the semiconductor substrate is
3 formed by a thermal treatment.

1 15. A method of fabricating a trench device
2 structure with a single-side buried strap, comprising the
3 steps of:

4 providing a semiconductor substrate having a pad
5 layer thereon and a deep trench therein;

6 forming a buried trench capacitor in a lower portion
7 of the deep trench;

8 forming a collar insulating layer lining an upper
9 portion of the deep trench

10 forming a first conductive layer overlying the
11 buried trench capacitor in the trench and
12 surrounded by and lower than the collar
13 insulating layer by a predetermined height;

14 sequentially forming a conformal lining layer and an
15 undoped polysilicon or amorphous silicon layer
16 on the surface of the pad layer and inner
17 surface of the deep trench above the first
18 conductive layer;

19 performing a tilt ion implantation on the undoped
20 polysilicon or amorphous silicon layer, wherein
21 a portion of the undoped polysilicon or

22 amorphous silicon layer in the deep trench is
23 not implanted;
24 selectively wet etching the undoped polysilicon or
25 amorphous silicon layer, thereby exposing the
26 underlying lining layer;
27 sequentially etching the exposed lining layer and
28 the contiguous collar insulating layer to
29 expose a portion of the semiconductor substrate
30 using the doped polysilicon or amorphous
31 silicon layer as a mask;
32 removal of the remaining lining layer and the doped
33 polysilicon or amorphous silicon layer;
34 forming a second conductive layer overlying the
35 first conductive layer in the deep trench,
36 wherein the second conductive layer is lower
37 than the surface of the semiconductor
38 substrate; and
39 performing a thermal treatment to form a buried
40 strap region on the semiconductor substrate
41 directly contacting the second conductive layer
42 without isolation by the collar insulating
43 layer.

1 16. The method as claimed in claim 15, wherein the
2 lining layer is composed of silicon nitride.

1 17. The method as claimed in claim 16, wherein the
2 thickness of the silicon nitride is approximately 100Å.

1 18. The method as claimed in claim 16, wherein the
2 undoped polysilicon or amorphous silicon layer and the

3 silicon nitride lining layer are formed by low pressure
4 chemical vapor deposition (LPCVD).

1 19. The method as claimed in claim 15, wherein the
2 thickness of the undoped polysilicon or amorphous silicon
3 layer is between 50 and 100Å.

1 20. The method as claimed in claim 15, wherein
2 dopant of the tilt ion implantation is BF₂ or B.

1 21. The method as claimed in claim 20, wherein the
2 tilt angle of the ion implantation is 7° to 15°.

1 22. The method as claimed in claim 20, wherein the
2 etching solution of the selectively wet etching is low
3 concentration ammonia solution.

1 23. A trench device structure with a single-side
2 buried strap, comprising:

3 a semiconductor substrate with a deep trench
4 therein;

5 a deep trench capacitor disposed on the lower
6 portion of the deep trench;

7 a first and second conductive layer sequentially
8 disposed on the deep trench capacitor in the
9 deep trench;

10 a collar insulating layer lining on the upper
11 portion of the deep trench to isolate the
12 entire first conductive layer and a portion of
13 the second conductive layer from the substrate,
14 wherein the un-isolated second conductive layer
15 directly contacts the substrate; and

16 a buried strap region disposed in the semiconductor
17 substrate directly contacting the second
18 conductive layer to form the single-side buried
19 strap.

1 24. The structure as claimed in claim 23, wherein
2 the collar insulating layer is composed of tetra ethyle
3 ortho silicate (TEOS).

1 25. The structure as claimed in claim 24, wherein
2 the thickness of the collar insulating layer is from 200
3 to 300Å.

1 26. The structure as claimed in claim 23, wherein
2 the first and second conductive layers are composed of
3 doped polysilicon.

1 27. The structure as claimed in claim 23, wherein
2 the semiconductor substrate is a silicon-based substrate
3 and the buried strap region in the semiconductor
4 substrate is a doped polysilicon region.

1 28. The structure as claimed in claim 23, wherein
2 the deep trench capacitor further comprises:

3 a polysilicon layer substantially filling the lower
4 portion of the deep trench;

5 an ion diffusion region disposed in the
6 semiconductor substrate, surrounding the
7 polysilicon layer; and

8 a dielectric layer disposed in the lower sidewall of
9 the deep trench, interposed between the
10 polysilicon layer and the ion diffusion region.